

Work Order ID 62991

Page 1

Friday, October 15, 2010 9:23:19 AM

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 10/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

11

Date: 10/10/15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3838	Rev A								
100		0.00							
	Large Fab								
Large Fab		0.00							
Large Fab	Memo								
	1- cut D3838-2 and D3838-3 rib as per dwg D3838								
	2- remove identification markings								
	3- deburr								
	4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838								
	A/R ER316 S.S. Rod Batch: 111585								
	5- c'sink hole as per dwg								
	6- grind weld flush where indicated on dwg D3838								
	7- weld D3759-1 bushing as per dwg D3838								
	A/R ER316 S.S. Rod Batch: 111585								
	8- grind bushing weld flush as per dwg dwg D3838								
	9- deburr hole if necessary								

SAD 10-10-18

2

10/10/19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



QC5- Inspect part completeness to step on W/O

0.00

2

10/10/19

QC

Memo

0.00

Quality Control

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

10/10/19

QC

Memo

0.00

Quality Control

130



Identify as per dwg & Stock Location: WA

0.00

SAO
10/10/19

Packaging

Memo

0.00

Packaging

2

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Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

10/10/2010
JMR
10-10-19

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Picklist Print

Page 1

Friday, October 15, 2010 9:23:24 AM

Work Order ID: 62991



Parent Item: D3838-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 10/15/2010

Required Date: 10/21/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 		Manufactured	No			100	Each	72.0000	1	2		<i>GJL 10-10-18</i>	

Bushing

M304TS0.750W.065



304 SQ Tube .75x.75x.065W

Purchased

No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST084	21	
56942	21	
WA	51	
54072	9	
61379	42	

678.6362	1.0317	2.172
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(2) SAD 10-10-18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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MAT	662.0818	
112398	0	
114482	0.0002	
115494	82.0816	
115593	580	
WA	16.554385	
114520	0.527385	
115274	16.027	

2172

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8

7

6

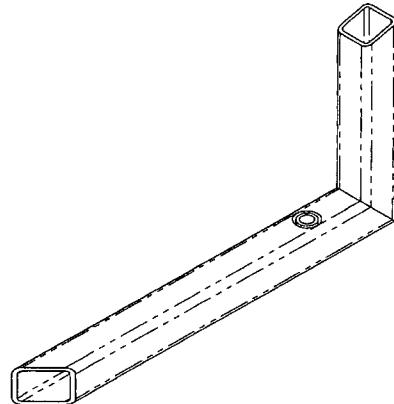
5

4

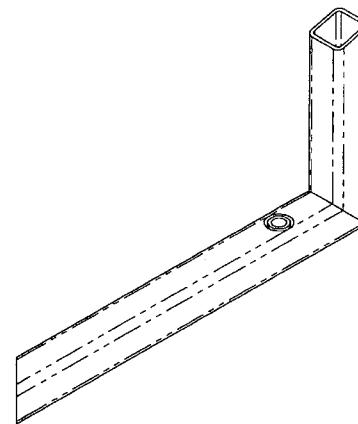
3

2

1



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

ITEM	QTY 041	QTY 042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. C2991
08/10/10

RELEASED
08/11/10

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>12</u>		
DRAWN	<u>12</u>		
CHECKED	<u>MS</u>		
MFG. APPR.	<u>AP</u>		
APPROVED	<u>AP</u>		
DE APPR.	<u>AP</u>		
DATE	08.10.08	SCALE	NTS
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. A
		D3838	SHEET 1 OF 3
		TITLE	SCALE
		RIB ASSY (BASKET LID)	NTS

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8

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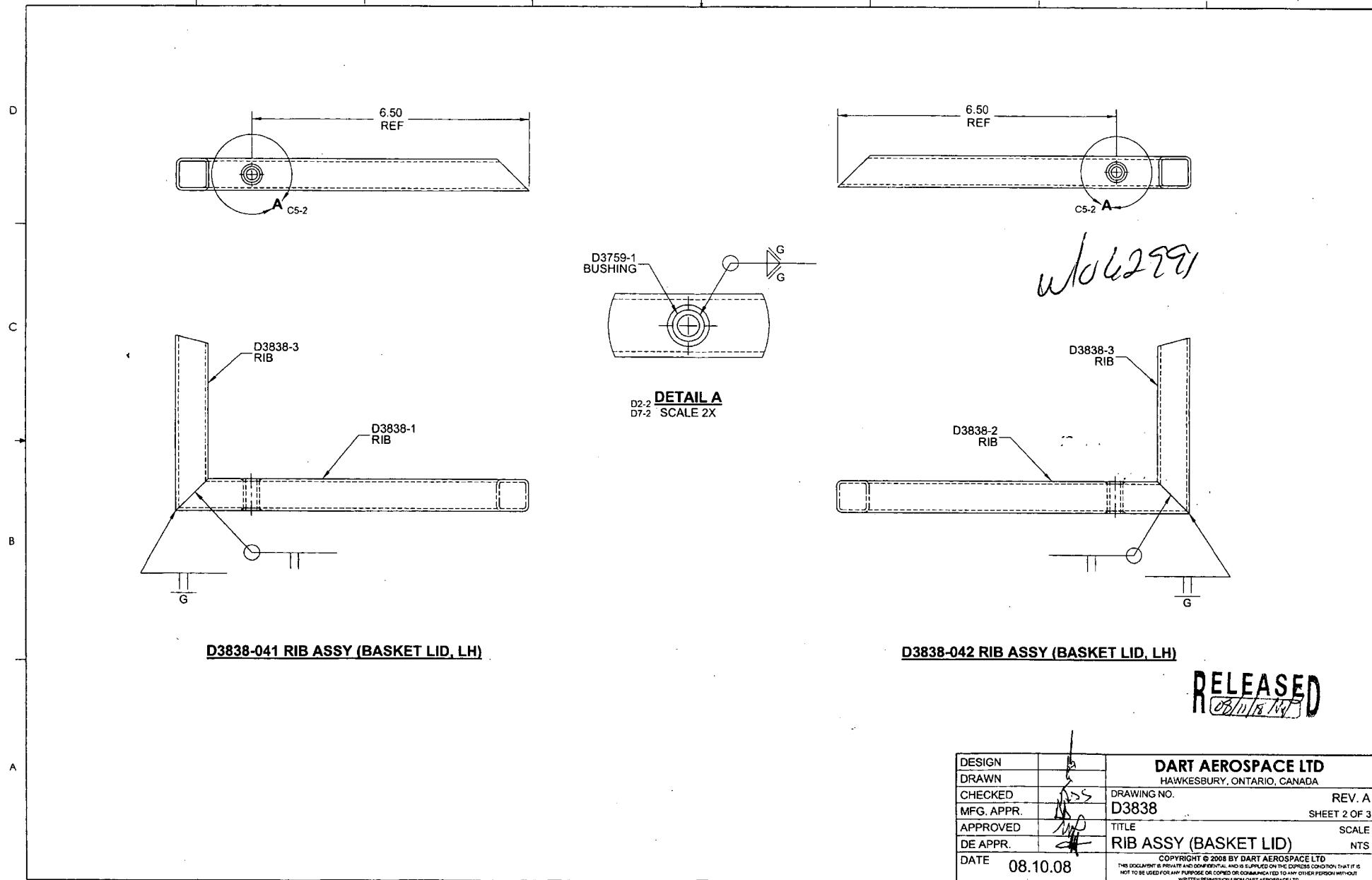
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8 7 6 5 4 3 2 1



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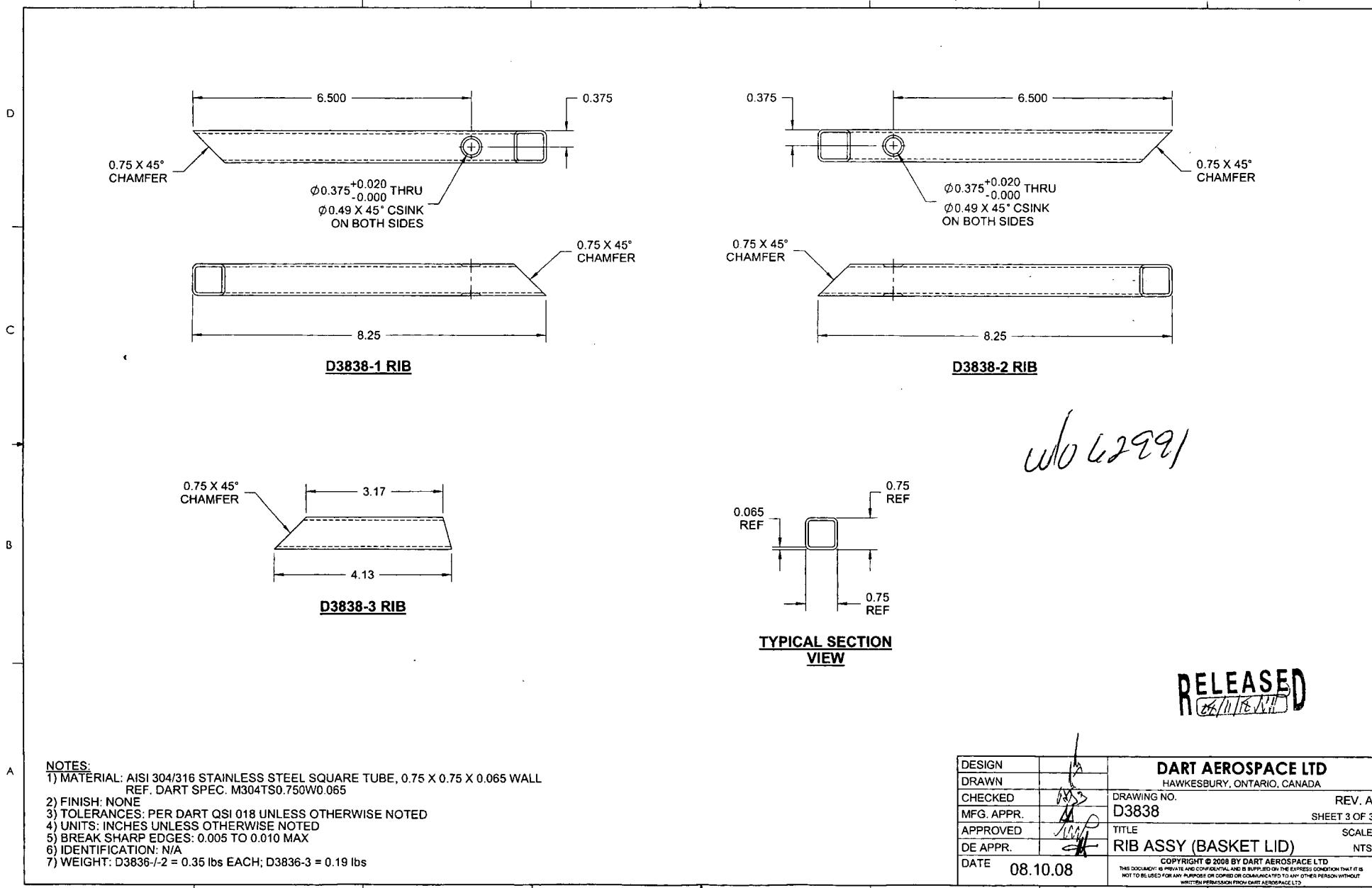
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